

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008023**Date Inspected:** 02-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuang Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG segments and tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG assembly bay 13

This QA observed no significant work was being performed in this bay during the time QA was present.

OBG assembly bay 14

This QA observed ZPMC personnel trial fitting corner assembly diaphragm identified as CSD6-PP078 to the bottom panel of corner assembly for OBG segment identified as 9CE.

This QA observed no other significant work was being performed in this bay during the time QA was present.

OBG subassembly bay 9

This QA observed ZPMC qualified welding personnel identified as 201250 perform FCAW welding on U-rib splice for deck panel DP-3043-001 weld joint identified as DP3043-001-023. ZPMC QC CWI identified as Mr. Sun Bo was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

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Tower bay 10

This QA observed ZPMC qualified welding personnel identified as 050041 perform FCAW repair welding on north tower shaft lift 1 weld joint identified as NSD1-A112B/H-4A/B. ZPMC QC CWI identified as Mr. Wang Chuang Qing was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-repair.

Tower bay 11

This QA observed ZPMC qualified welding personnel identified as 053916 perform SMAW welding on lift 4, west tower shaft stiffener to skin C weld joint identified as WSD1-FCA4-2C/C-14B. ZPMC QC identified as Mr. Fu Wei Min was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3212-Tc-U5b-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
